

Work Order ID 65162

Thursday, January 06, 2011 3:34:45 PM



Page 1

Item ID: D3651-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 1/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-01-7

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3651

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3651 ☒ Dwg Rev: B ☐ Prog Rev: B ☐ 2-Deburr if necessary

B 11-1-19

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B 11-1-19

(4)

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Sublot 120

(x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65162

Thursday, January 06, 2011 3:34:45 PM



Page 2

Item ID: D3651-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 1/6/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: C-A

0.00

Memo

0.00

SO 11/01/20

(4)

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/01/20

ME

11-01-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, January 06, 2011 3:34:50 PM

Page 1
1

Work Order ID: 65162



Parent Item: D3651-11



Parent Item Name: Gasket



Start Date: 1/6/2011

Required Date: 1/14/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-09-27 DD verified by: EC
 IPP Rev:B ECN 1113P 08-01-22 DD
 IPP Rev:C ecn1162 08-04-02 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
G89  coated cloth		Purchased	No			100	sf	6.2000	0.686	2.888421			
												11-1-19	

Location

Loc Qty

Loc Code

mat50

6.2

109805

6.2

109805

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 65162
Description: Gasket		Part Number: D3651-11
Inspection Dwg: D3651 Rev: B		Page 1 of 1

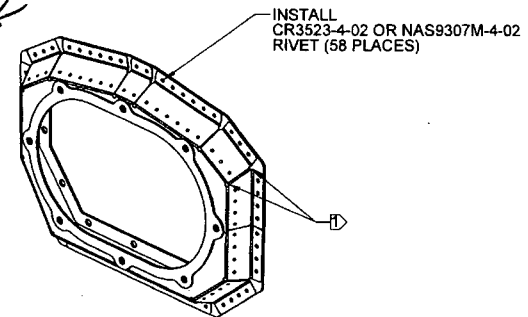
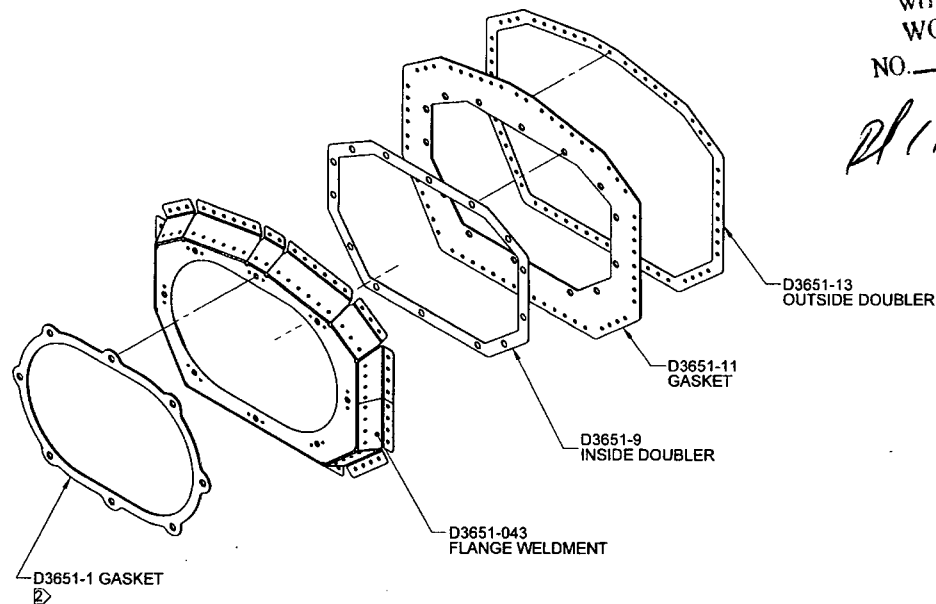
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	129	x		V B02	
Ø0.250	+0.005/-0.001	250	x		V	
8.74	+/-0.030	8.73	x		T B 61	
11.62	+/-0.030	11.61	x		T	
1.62	+/-0.030	1.60	x		V 11	
1.41	+/-0.030	1.41	x		V	
0.500	+/-0.010	.500	x		V	
0.600	+/-0.010	.600	x		V	
0.634	+/-0.010	.634	x		V	
2.564	+/-0.010	2.561	x		V	
2.081	+/-0.010	2.081	x		V	
3.731	+/-0.010	3.731	x		V	
2.100	+/-0.010	2.100	x		V	
9.706	+/-0.010	9.704	x		T	
7.969	+/-0.010	7.969	x		V	
6.96	+/-0.030	6.96	x		V	
5.698	+/-0.010	5.698	x		V	
3.698	+/-0.010	3.698	x		V	
2.564	+/-0.010	2.562	x		V	
2.020	+/-0.010	2.020	x		V	
3.284	+/-0.010	3.284	x		V	
2.200	+/-0.010	2.200	x		V	
2.750	+/-0.010	2.751	x		V	
9.521	+/-0.010	9.520	x		T	
10.22	+/-0.030	10.22	x		T	
1.373	+/-0.010	1.373	x		V	
1.62	+/-0.030	1.62	x		V	
3.564	+/-0.010	3.564	x		V	
4.236	+/-0.010	4.234	x		V	
5.636	+/-0.010	5.634	x		V	
7.049	+/-0.010	7.047	x		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-1-19	Date: 11/01/20	Date:	N/A
Rev	Date	Change	Revised by Approved
A	08.04.17	New Issue	KJ/DD [Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 65162
211-01-7



PART LIST

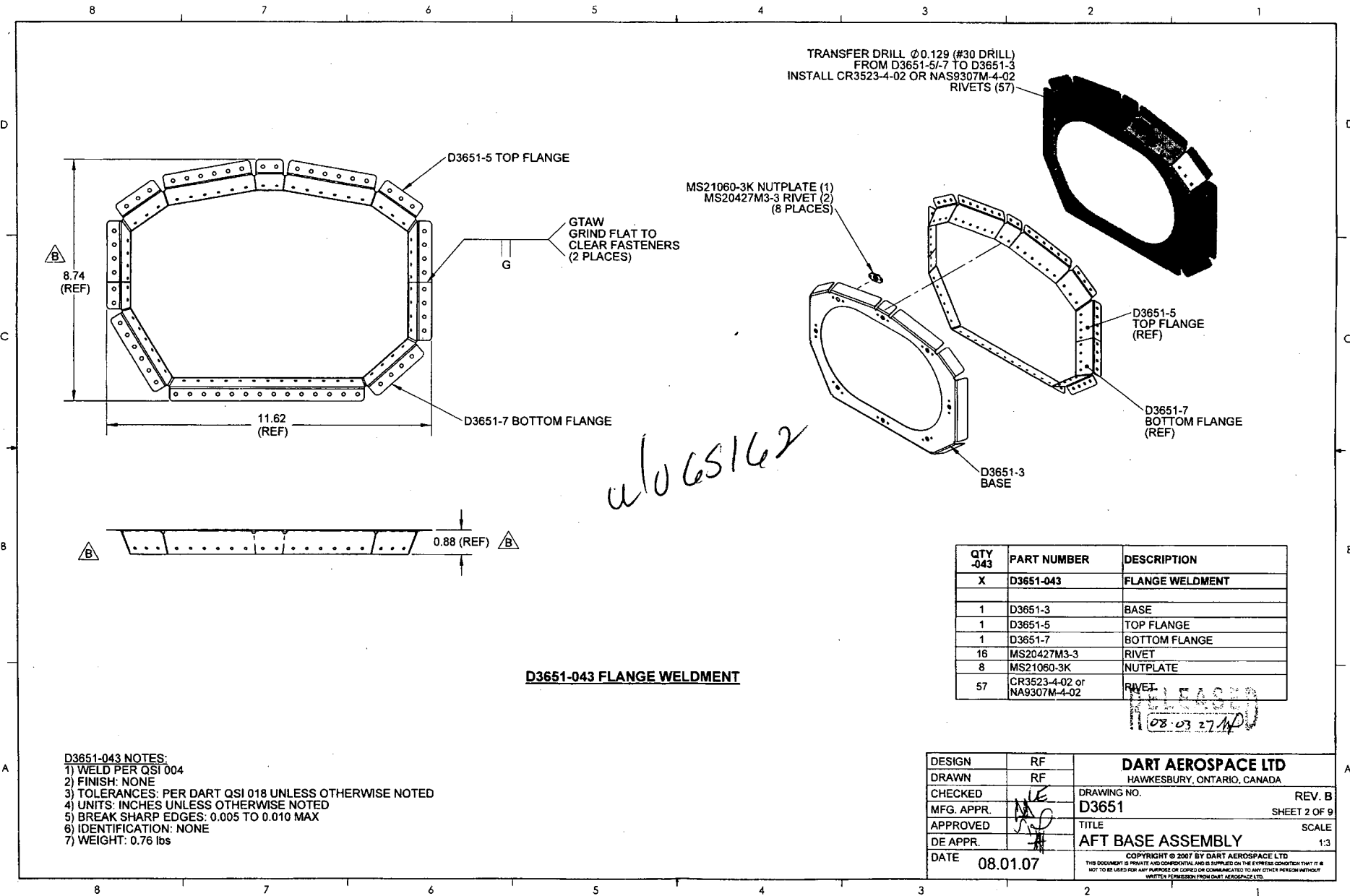
QTY -041	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

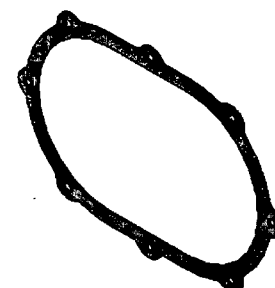
D3651-041 AFT BASE ASSEMBLY

D3651-041 NOTES:

- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
- 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.6 lbs

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50, 0.88 WAS 0.98; REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3651	SHEET 1 OF 9
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AFT BASE ASSEMBLY	1:4
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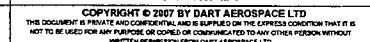


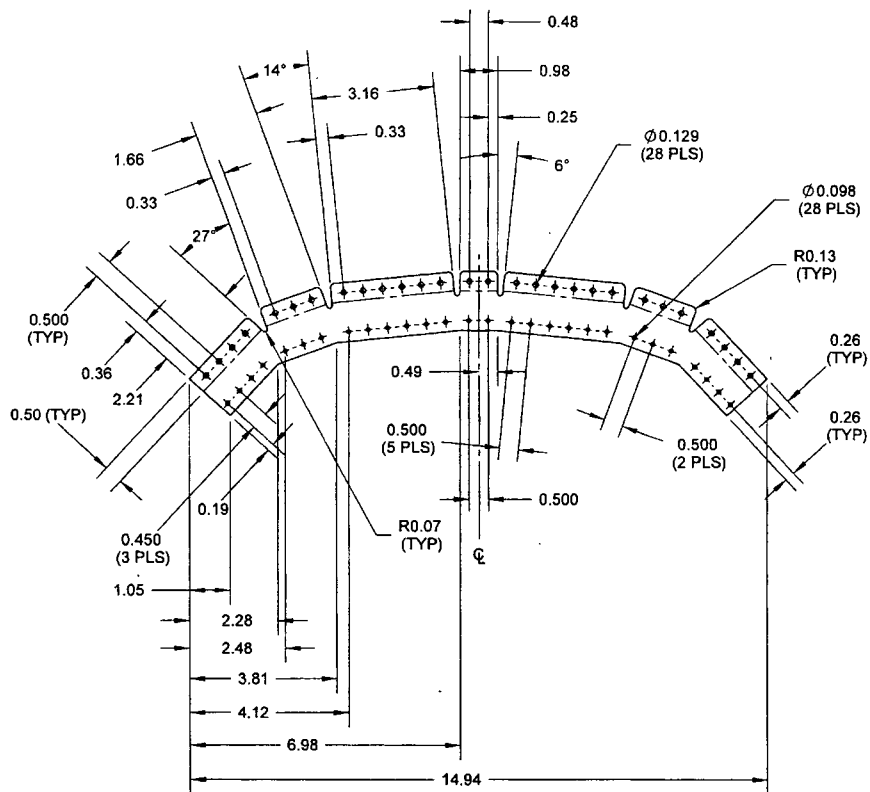


w/o 45/42

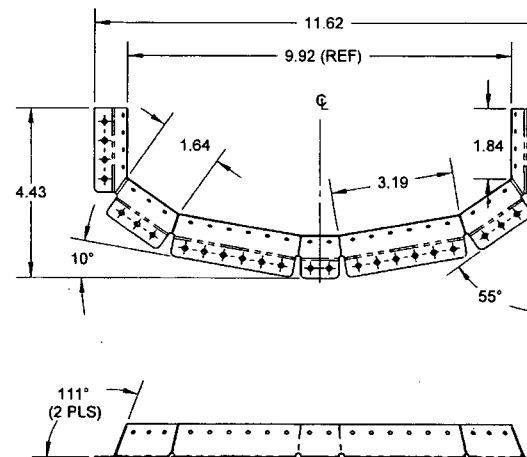
08-03-27 *MD*

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D3651-5F FLAT PATTERN

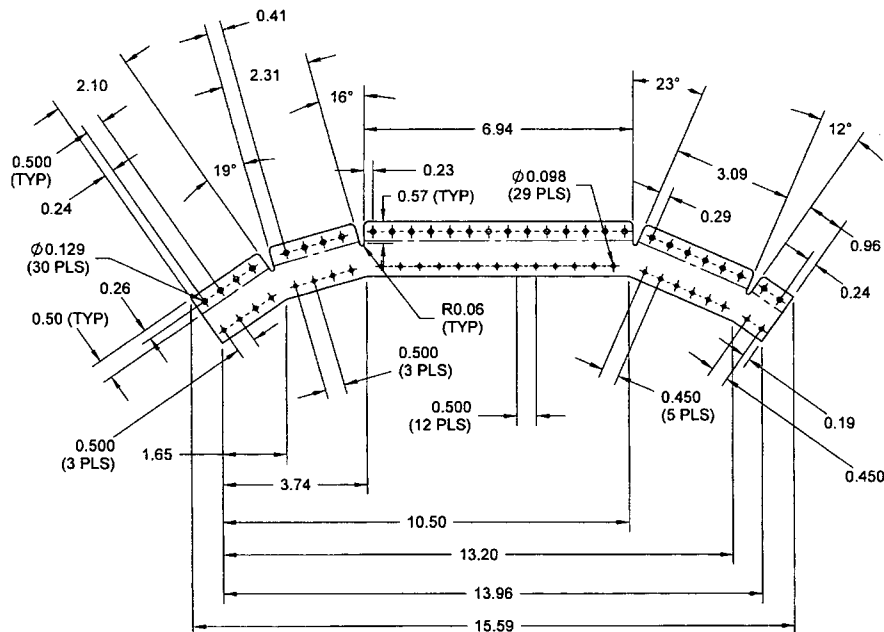


D3651-5 TOP FLANGE BEND DETAIL
(MAKE FROM D3651-5F FLAT PATTERN)

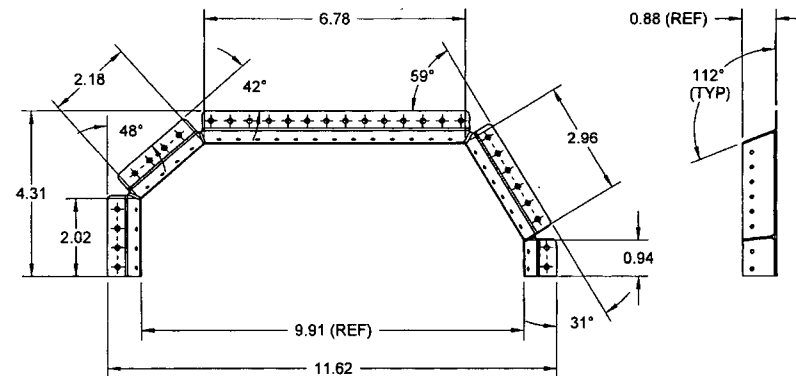
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 5 OF 9
APPROVED		TITLE	SCALE
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D3651-7F FLAT PATTERN

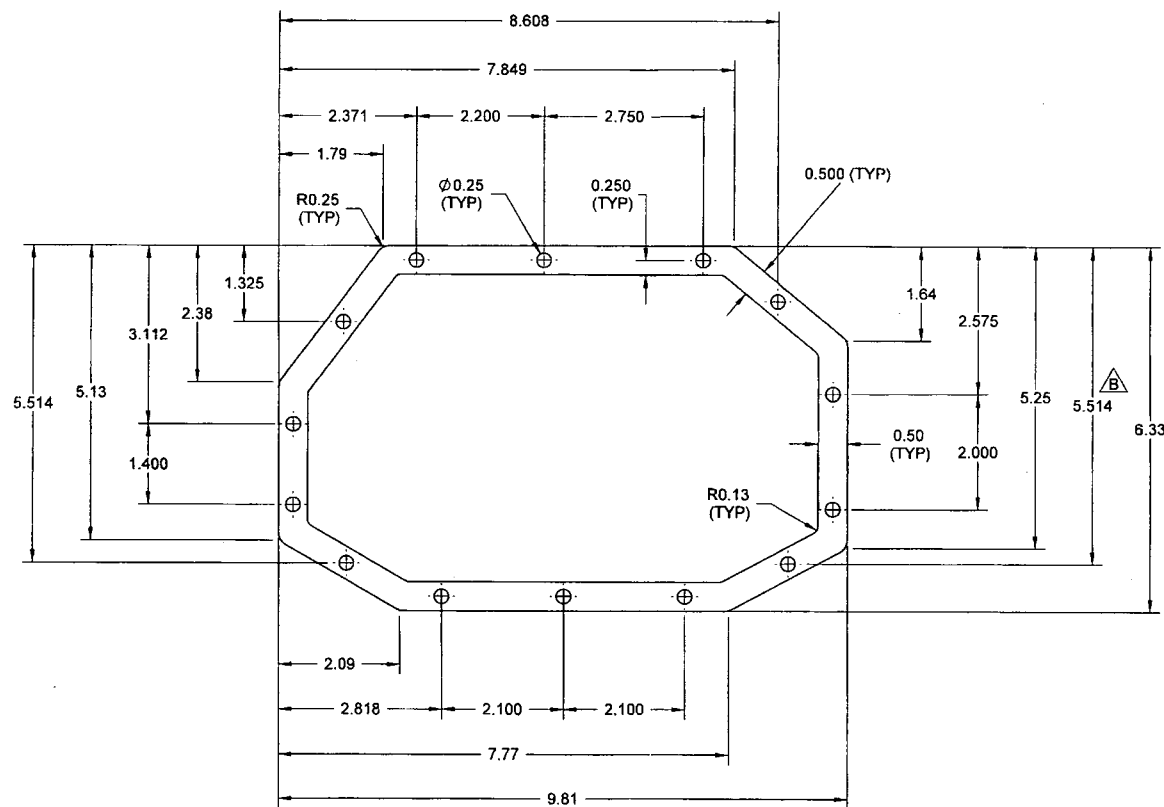


D3651-7 BOTTOM FLANGE BEND DETAIL
(MAKE FROM D3651-7F FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	KE	DRAWING NO. D3651	REV. B
MFG. APPR.	TOP	SHEET 6 OF 9	
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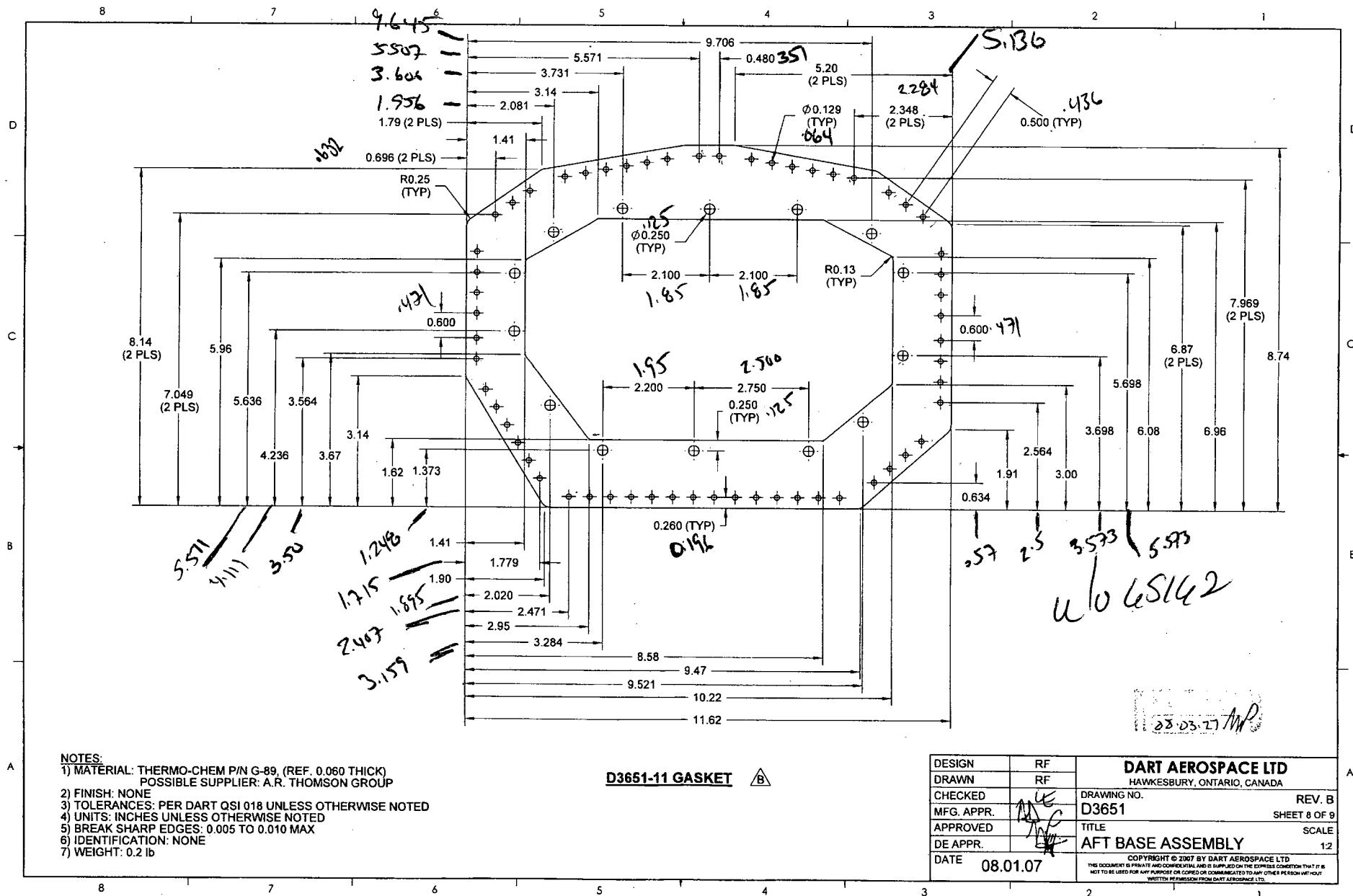
u/o 65142

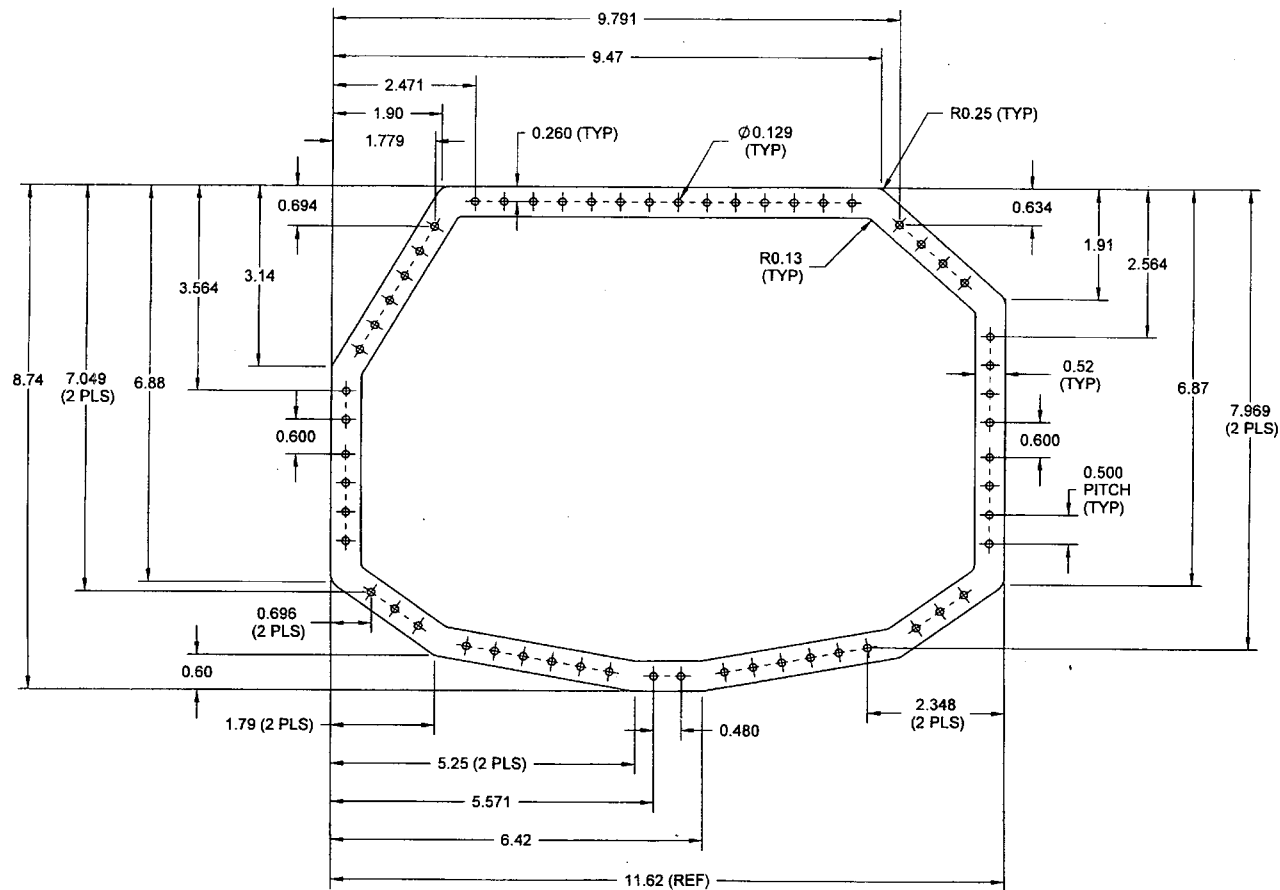
D3651-9 INSIDE DOUBLER

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	WLE	D3651	SHEET 7 OF 9
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





D3651-13 OUTSIDE DOUBLER 

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3651	SHEET 9 OF 9
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w/065162

08-03-27 MP